

# Work Order ID 117601

Monday, April 28, 2014 1:44:01 PM

**\*117601\***

Page 1

Item ID: D2855-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cap  
 Start Date: 4/28/2014 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 5/19/2014 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: CZ Date: 14/04/28 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								

100 PURCHASING 0.00  
**\*100\***  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 24003  
 Cast per Dwg D2855  
 Material Release Note Required

CZ 14/04/29 30

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging Ensure Material Release Note is attached

CZ 14/06/10 2 50

120 QC6- Inspect dimensions to drawing 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control

DAS  
27  
9-89  
14/6/18

POSITIVE RECALL  
 EFFECTIVE 14/06/13 AUTH u Certs  
 RELEASED Shi DATE 14/6/19

# Work Order ID 117601

Monday, April 28, 2014 1:44:01 PM

**\*117601\***

Page 2

Item ID: D2855-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Cap  
Start Date: 4/28/2014 Start Qty: 50.00 **\*50\*** Cust Item ID:  
Required Date: 5/19/2014 Req'd Qty: 50.00 **\*50\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Cut to length as per dwg 4- Deburr								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:35 OVEN TEMPERATURE: 320 FINISH TIME: 9:05								

DAS  
20  
9-89

FF 14-06-13

14-06-13 (8)

68-6  
27  
SVD

14/6/13

8

8 14-6-16

DAS  
34  
9-89

**Work Order ID 117601**

Monday, April 28, 2014 1:44:01 PM

**\*117601\***

Page 3

Item ID: D2855-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cap

Start Date: 4/28/2014 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 5/19/2014 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

8x d M 10/06/16

68-  
91-  
SVO

170

Small Fab

0.00

**\*170\***

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

8x 6 M 10/06/16

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

8x 6 14-6-16

DAS  
34  
9-89

# Picklist Print

Monday, April 28, 2014 1:44:00 PM

Page 1

Work Order ID: 117601

**\*117601\***

Parent Item: D2855-3

**\*D2855-3\***

Parent Item Name: Cap

Start Date: 4/28/2014

Required Date: 5/19/2014

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	1,177.000	2	100	16	11/06/12	
<b>*AI S7-1032-225*</b>									<b>**</b>				
Insert													

## Location

## Loc Qty

## Loc Code

FG	80	
118520	80	
FP001	1000	
m128649	1000	
ST280	97	
m128179	97	

D2855P

Purchased

No

110

Each

0.0000

1

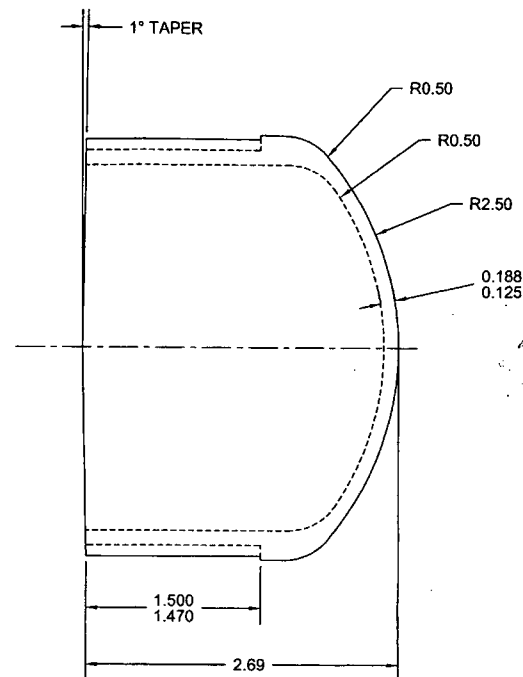
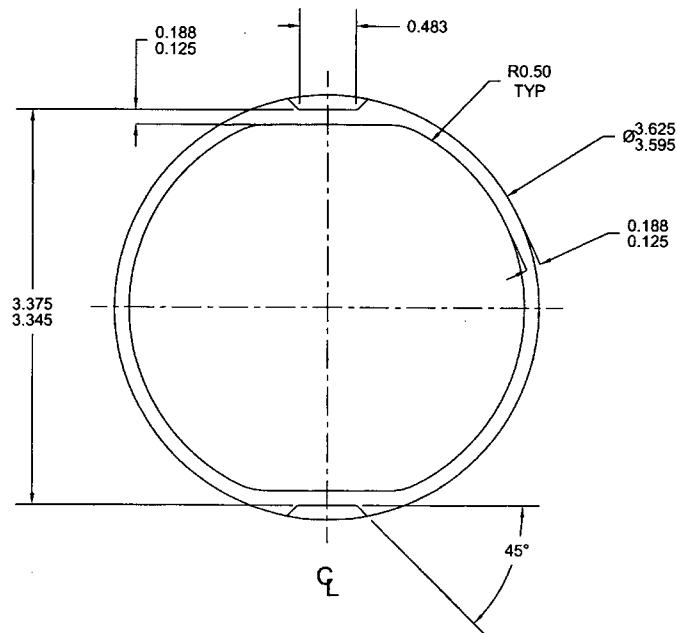
50

**\*D2855P\***

Cap

**\*\***

02/14/06/02 30



# D2855C CASTING DETAIL



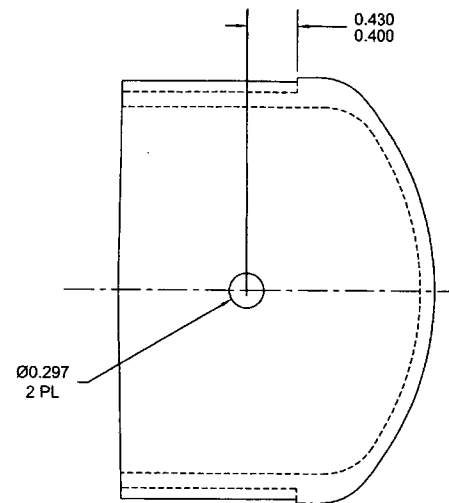
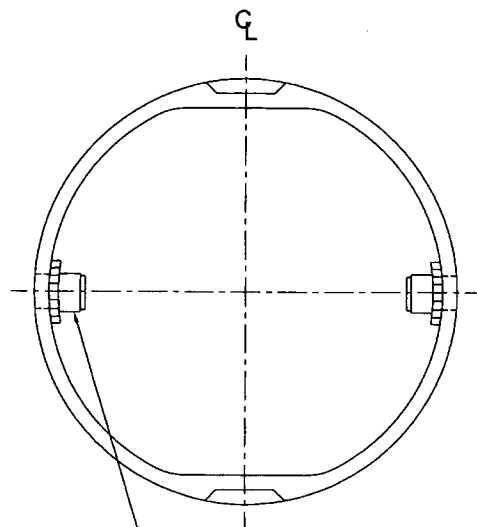
## NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

CZ14/04/28  
W10:117601

RELEASED

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

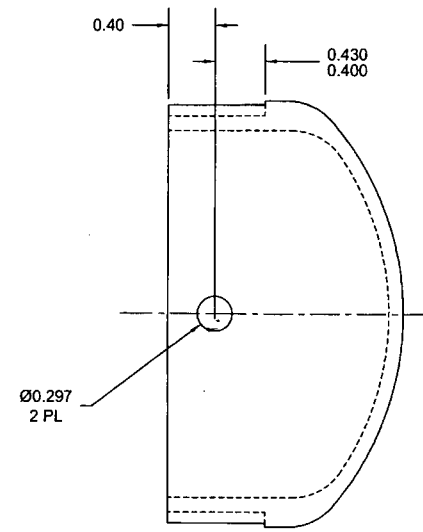
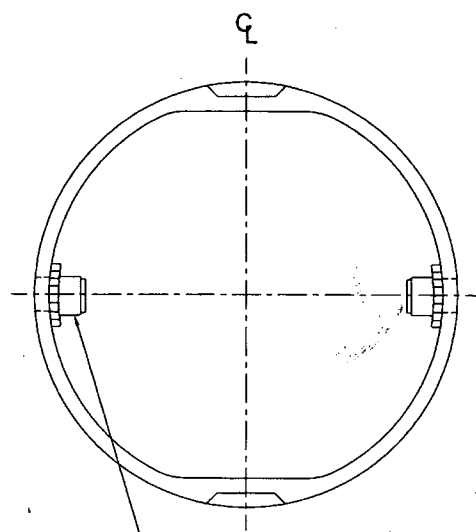
**D2855 CAP**  
(MAKE FROM D2855C CASTING)

**RELEASED**  
31/07/15


**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

**D2855-3 CAP**   
(MAKE FROM D2855C CASTING)

**RELEASED**  
*09/07/13 MB*

**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO24003

Purchase Order Date 4/29/2014

PO Print Date 5/1/2014

Page Number 1 of 2

Order From :

METALLURGIE SYCA  
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

VC-MSY01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

REVISED \$

Contact Name

Vendor Phone 450-261-0853

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

**FAKED**  
6/14/05/01

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P	Cap ✓	5/23/2014 Yes 5/23/2014		50.00 Each	\$12.50	\$625.00

CAST AS PER DWG D2855 REV. B  
B117602

*Nic 55*

Line Total: \$625.00

2	D2855P	Cap ✓	5/23/2014 Yes 5/23/2014		50.00 Each	\$12.50	\$625.00
---	--------	-------	-------------------------------	--	---------------	---------	----------

CAST AS PER DWG D2855 REV. B  
B117601

*14/06/02*

*14/6/13*

Line Total: \$625.00

Note:

5/1/2014



N° D'ENR. DE TAXE  
TAX REG. NO.

N° DE COMMANDE  
ORDER NO.

VENDU A  
SOLD TO

ADRESSE  
ADDRESS

EXPÉDIÉ A  
SHIP TO

ADRESSE  
ADDRESS

DATE

30 Mai 2014

24003

Dart Aerospace Ltd

1270 ABERDEEN STREET

HAWKSBURY ONTARIO

K6A 1K7

DATE D'EXPÉDITION  
SHIPPING DATE

VIA

CONDITIONS  
TERMS

ACHETEUR  
BUYER

VENDEUR  
SALESPERSON

111

D-2855

1 BOITE X 55 PCS X 30 POUNDS

1 BOX X 56 PCS X 31 POUNDS

Transport Fedex

Thanks for your support

TOTAL

931352

SIGNATURE

BlueLine DCB27

FORMULAIRE DE VENTE - SALES ORDER

©BlueLine® 2010





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

# PURCHASE ORDER

Purchase Order ID PO24003

Purchase Order Date 4/29/2014

PO Print Date 5/1/2014

Page Number 1 of 2

Order From :

VC-MSY01

METALLURGIE SYCA  
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

Ship To : DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

REVISED \$

Contact Name

Vendor Phone 450-261-0853

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

FOKED  
C 5/1/05/10

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pr
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	--------------

1 D2855P

Cap

5/23/2014

Yes

5/23/2014

50.00

Each

\$12.50

\$625.00

CAST AS PER DWG D2855 REV. B  
B117602

Net 55

2 D2855P

Cap

5/23/2014

Yes

5/23/2014

50.00

Each

\$12.50

\$625.00

CAST AS PER DWG D2855 REV. B  
B117601

C 14/10/01/02

2014/6/13

Line Total:

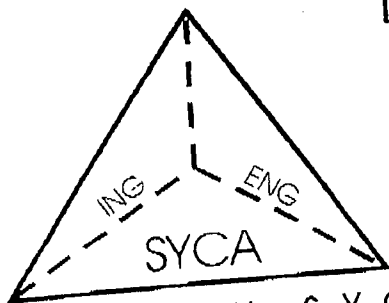
\$625.00

Line Total:

\$625.00

Note:

5/1/2014



# MÉTALLURGIE SYCA Inc.

500, Principale  
St-Dominique, Québec  
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

WWW.SYCA-INC.COM

## CERTIFICATE OF COMPLIANCE

DATE: 2014-05-30

COMPANY: DART AEROSPACE LTD  
1270, ABERDEEN STREET  
HAWKSBURY, ONTARIO  
K6A 1K7

SHIPPING MEMO: 931125

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	111	D-2855	24003

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ21052014

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONNAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101